



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3189-3

Job Sheet 183217



DAS
21
9-89

12

Part No: D3189-3

Job Qty: 10 ea

Part Name: Chafing Shield



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/13/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP A 07.04.04 new issue EC IPP REV:B 14.02.12 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		9/28/18	0.00	0.00	Start Up Waterjet		SC 8/29/18
100	Waterjet	10 pcs		9/28/18	0.00	0.26	Waterjet1		SC 8/29/18
103	QC	10 pcs		9/28/18	0.00	0.00	QC2 Waterjet-1		SC 8/29/18
105	QC	10 pcs		9/28/18	0.00	0.00	QC8-2		SEP 17 2018 68
110	Small Fab	10 pcs		9/28/18	0.00	0.88	Small Fab-3		SEP 17 2018 9-89
120	QC	10 pcs		9/28/18	0.00	0.00	QC5		SEP 17 2018 9-89
122	HandFinish	10 pcs		9/28/18	0.00	0.00	HandFinish4		SEP 17 2018 9-28
125	QC	10 pcs		9/28/18	0.00	0.00	QC3		SEP 17 2018 38
130	Packaging	10 pcs		9/28/18	0.00	0.00	Packaging3-1	LG052	SEP 17 2018 68
140	QC21-SA	10 Ea		9/28/18	0.00	0.00	QC21		SEP 17 2018 68

Part Op 103 - QC2- Inspect parts off machine FAI/FAIB

Descriptions: 105 - QC8- Inspect parts - second check

120 - QC5- Inspect part completeness to step on W/O

125 - QC3- Inspect Part Finish

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

DAS
21
9-89

OCT 09 2018

ROSEN 5096394 EXPR 03/19

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S24GA	304/316 .025 Sheet	2.1000 sf (.21 ea)	90-Start up Operation	8007176

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S24GA	2	58	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Chafing Shield	2.380inches ± 0.030	2.410 2.350	2, 383	
2	Chafing Shield	10.000inches ± 0.030	10.030 9.970	10,000	
3	Chafing Shield	0.020inches ± 0.010	0.030	0,023	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																
Date : _____ Sten #: _____		MRB (QSI042) Approval																																																																																																																																
Dart Aerospace Ltd. 1270 Alburden Street Heckesbury, ON K64 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaero.com Description Work Order Disposition		Disposition																																																																																																																																
		Completed By																																																																																																																																
		Lead hand / Supervisor Approval Verification																																																																																																																																
		QC / QA Coordinator Approval																																																																																																																																
 Container No: S110410 Part: D3189-3 Job No: 183217 Serial No/Batch: S110410 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:20%;">Environment</td> <td style="width:20%;"></td> <td style="width:20%;"></td> <td style="width:20%;"></td> <td style="width:20%;"></td> <td style="width:20%;"></td> </tr> <tr> <td>Design</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Doc/Da</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Equip/Toolin</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Handling/Pl</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Material</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Internal Transport</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Tribal Knowledge</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>LOA</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Substation</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Past Expiry Date</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Environment						Design						Doc/Da						Equip/Toolin						Handling/Pl						Material						Internal Transport						Tribal Knowledge						LOA						Substation						Past Expiry Date						Misidentified						<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:20%;">Crimp/Kink/Ripple/Wave</td> <td style="width:20%;"></td> <td style="width:20%;"></td> <td style="width:20%;"></td> <td style="width:20%;"></td> <td style="width:20%;"></td> </tr> <tr> <td>Cuffs</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Crushing</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Heat Treat</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Wave/Twist in Tube</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Marks/Chatter</td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Crimp/Kink/Ripple/Wave						Cuffs						Crushing						Heat Treat						Wave/Twist in Tube						Marks/Chatter						CATEGORY <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:20%;">☐ Power Loss/Surge</td> <td style="width:20%;">☐ Positioned Wrong</td> </tr> <tr> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Mislabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
Environment																																																																																																																																		
Design																																																																																																																																		
Doc/Da																																																																																																																																		
Equip/Toolin																																																																																																																																		
Handling/Pl																																																																																																																																		
Material																																																																																																																																		
Internal Transport																																																																																																																																		
Tribal Knowledge																																																																																																																																		
LOA																																																																																																																																		
Substation																																																																																																																																		
Past Expiry Date																																																																																																																																		
Misidentified																																																																																																																																		
Crimp/Kink/Ripple/Wave																																																																																																																																		
Cuffs																																																																																																																																		
Crushing																																																																																																																																		
Heat Treat																																																																																																																																		
Wave/Twist in Tube																																																																																																																																		
Marks/Chatter																																																																																																																																		
☐ Power Loss/Surge	☐ Positioned Wrong																																																																																																																																	
☐ Folio/Program	☐ Outside Dimensions																																																																																																																																	
☐ Grain	☐ Over/Under tolerance																																																																																																																																	
☐ Weld	☐ Part Incorrect																																																																																																																																	
☐ Wrong Stock Pulled	☐ Part Lost/Missing																																																																																																																																	
☐ Out of Sequence	☐ Part Moved																																																																																																																																	
☐ Off-set	☐ Drawing																																																																																																																																	
☐ Mislabeled	☐ Finish																																																																																																																																	
☐ Fit/Function	☐ Misread																																																																																																																																	
☐ Misaligned/off center	☐ Turning Sequence																																																																																																																																	
OTHER : _____																																																																																																																																		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					